

SPLIT-1

# Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 1

Item ID: D3849-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00 <sup>1.62</sup>

Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00 <sup>1.6</sup>

Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 09-09-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3849	B
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(PH) →

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3849

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B 9-9-30

(7)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-30

W/O: 52402

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05/10/01	100	update DXF program per NC below  <i>per change</i>	<i>[Signature]</i>	09/11/30		<i>[Signature]</i> 05/10/01	<i>[Signature]</i> 05/10/01

→ D119-646

Part No: D 3849-043 PAR #: N/A Fault Category: prod eng coordinator NCR: Yes No DQA: [Signature] Date: 09.12.08  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed Date: 05.12.11

NCR: 52402

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/01	# 100	Part is too long and has 2x 0.86" x 0.125" slots in wrong place. R.C. DXF/Program was never updated	<i>[Signature]</i>	<del>Scrap and Deburr and</del> <del>Replace Q14 (First part was wrong)</del> <del>Make new Pump</del> <i>NIA</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i> 09/10/01
			<i>[Signature]</i>	- UPDATE Program - Do not scrap parts. Skew: deburr part to length per chg. record NC on FAI & do measurement	<i>[Signature]</i> 9-10-1	<i>[Signature]</i> 09/10/01	<i>[Signature]</i>	<i>[Signature]</i> 05/10/01

NOTE: Date &amp; initial all entries

# Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 2

Item ID: D3849-043

Accept



Setup Start



Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Stop



Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 802/01/01

(X7)

f

130

Brake NC  
Memo

0.00



Brake NC

Memo

0.00

Brake NC

Form as per dwg using DT8179 & DT8155

28 09/00/05

7

o

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 802/01/02

(X7)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 52402

September 22, 2009 11:33:06 AM



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Item ID: D3849-043  
 Revision ID: B  
 Item Name: AFT WEARPLATE ASSY, STD GEAR  
 Start Date: 09/23/2009 Start Qty: 2.00  
 Required Date: 10/02/2009 Req'd Qty: 2.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
	Large Fab								
	Memo	0.00							
	1- On D3901 bar, fill cut outs with hardcoat welding rod as per dwg D3849 2059 B Hardcoat Welding Rod BATCH#: <u>M112 963</u>								
	2- Weld D3901 bar to wearplate by positioning holes together as per dwg D3849 304 S.S. Welding Rod BATCH #: <u>M102 421</u>								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
	Memo	0.00							
	Quality Control								

AL 9-11-20 (X2)

AD 09.11.23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 4

Item ID: D3849-043  
Revision ID: B  
Item Name: AFT WEARPLATE ASSY, STD GEAR

Accept



Setup Start



Stop



Start Date: 09/23/2009 Start Qty: 2.00  
Required Date: 10/02/2009 Req'd Qty: 2.00



Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S or 11/23

Memo

0.00

(42)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112558

0.00

=> 09/11/25

Memo

START TIME: 7:15AM  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 7:45AM

0.00

(X2)

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

=> M, L 09/11/25 2X

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 52402**

September 22, 2009 11:33:06 AM

Page 5

Item ID: D3849-043

Accept

Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009 Start Qty: 2.00

Required Date: 10/02/2009 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D3848 gasket to inner surface of wearplate using a thin layer of 3m  
1300/1300L scotch grip adhesive as per dwg D3849  
BATCH: 7113174

09/25/09 (2)

210

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

=&gt; 09/26/09

(42)

220

0.00



Packaging

Identify as per dwg &amp; Stock Location: HP-18

Memo

0.00

Packaging

BR 09-11-26

(2) 4.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52402**

September 22, 2009 11:33:06 AM



Page 6

Item ID: D3849-043  
Revision ID: B  
Item Name: AFT WEARPLATE ASSY, STD GEAR  
Start Date: 09/23/2009 Start Qty: 2.00  
Required Date: 10/02/2009 Req'd Qty: 2.00  
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/30

B/09-11-30 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 22, 2009 11:33:05 AM

Page 1

Work Order ID: 52402

Parent Item: D3849-043RevB

Parent Item Name: AFT WEARPLATE ASSY, STD GEAR




Start Date: 09/23/2009

Required Date: 10/02/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty/To Pick	Qty Issued	Date Issued	Status
D3848-3RevB 		Manufactured	No				Each	0.0000	2.0000			
Gasket D3901-3RevB 		Manufactured	No				Each	0.0000	2.0000			
Bar M304S18GA 		Purchased	No				sf	183.4395	6.4211			
304/316 .050 Sheet												

B52531

5305348

9-25

9-11-25

20.4738

189-9-30

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

183.4395053

108156

0.98526316

111743

23.7174

112178

158.736842

112178

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52402
<b>Description:</b> DFT WEARPLATE ASSY STD GFAD		<b>Part Number:</b> D3849-043
<b>Inspection Dwg:</b> D3849-3 Rev: B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 375	+ .006 - .001	377	*			
.125	± .010	.128	*			
.88	± .020	.880	*			
.25	± .030	.252	*			
2.45	± .030	2.45	*			
4.38	± .030	4.384	*			
7.00	± .030	7.005	*			
51.000	± .010	51.008	*			
66.87	± .030	66.875	*	73.500"		
Ø .188	+ .005 - .001	.192	*			
2.433	± .010	2.430	*			
6.640	± .010	6.639	*			
18.712	± .010	18.712	*			
36.629	± .010	36.629	*			
62.799	± .010	62.799	*			
4.00	± .030	4.007	*			
7.72	± .030	7.709	*			
.050	± .010	.050	*			

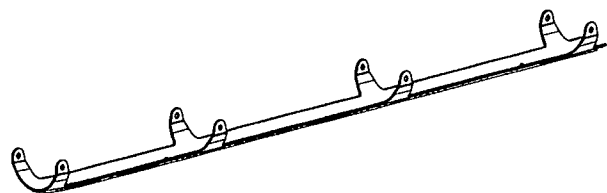
<b>Measured by:</b>	LB
<b>Date:</b>	9-9-30

<b>Audited by:</b>	S
<b>Date:</b>	02/10/61

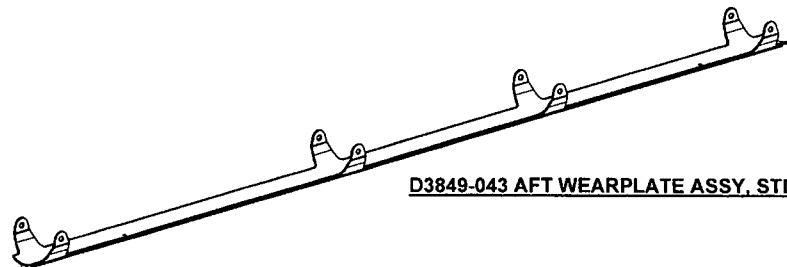
<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

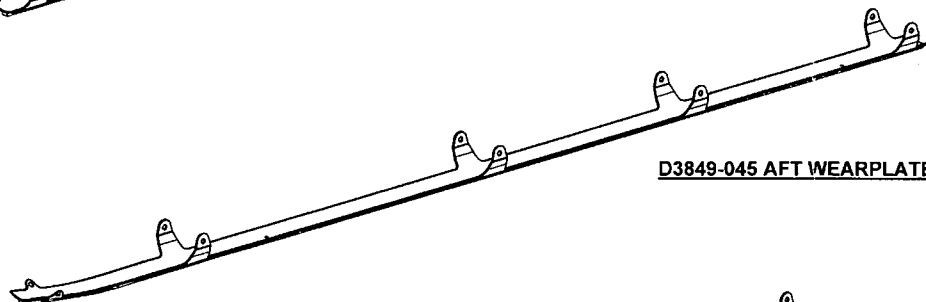
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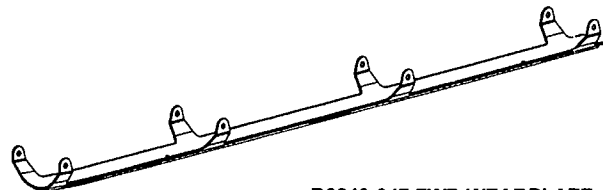
**D3849-041 FWD WEARPLATE ASSY, STD GEAR**



**D3849-043 AFT WEARPLATE ASSY, STD GEAR**



**D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR**



**D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR**

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

#52402

RELEASED  
2/6/75

B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/3F/5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.4 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A5-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.35 (ZN S4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	PH		
MFG. APPR.	EO		
APPROVED	AW		
DE APPR.	HT		
DATE	09.06.30		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3849	REV. B SHEET 1 OF 10
TITLE WEARPLATE ASSY	SCALE NTS
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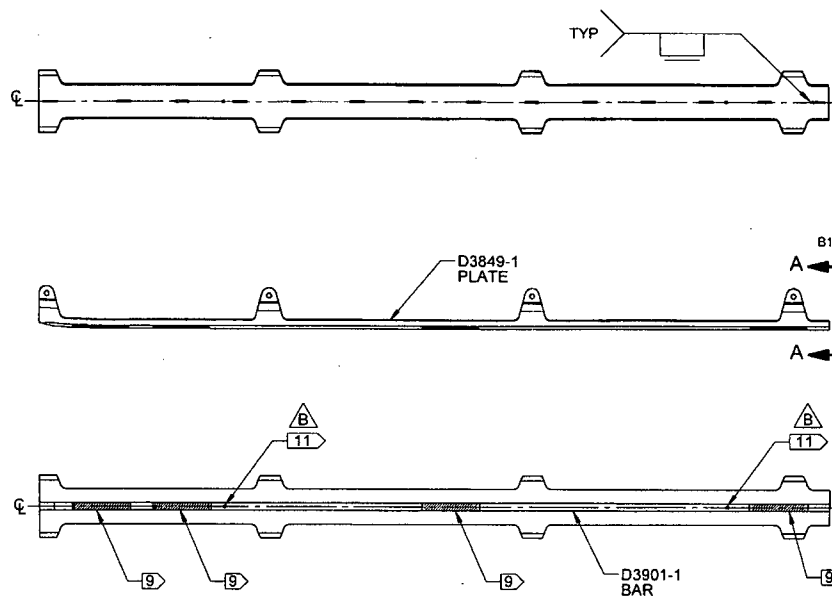
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

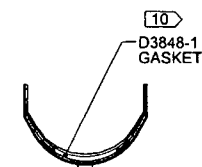


**D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR** B

**NOTES:**



- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\phi$ 0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

#52402



**SECTION A-A** C3-2  
SCALE 2X

**RELEASED**  
18/07/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 2 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR IS ASSOCIATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

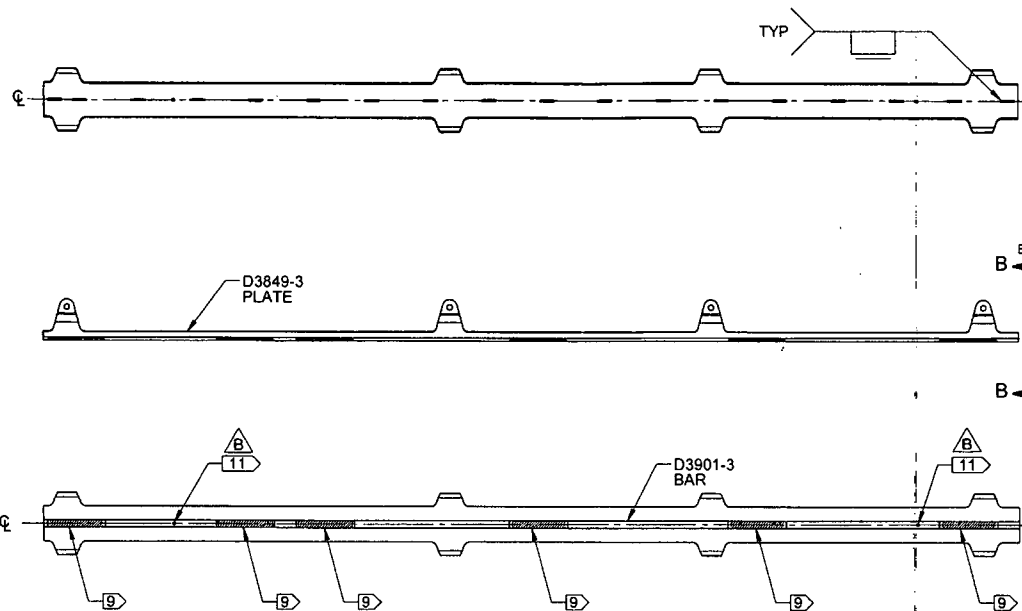
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3849-043 AFT WEARPLATE ASSY. STD GEAR**

**SECTION B-B C2-3**  
SCALE 2X

**RELEASED**  
10/27/15

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\varnothing$ 0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BAR

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3849</b>	SHEET 3 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>WEARPLATE ASSY</b>	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

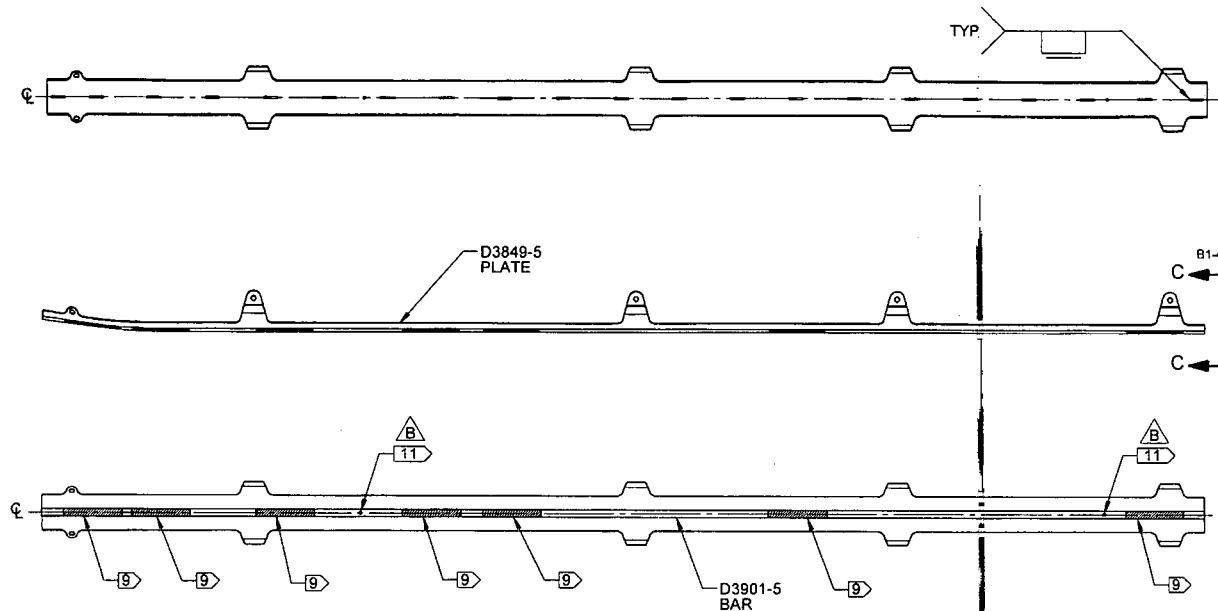
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

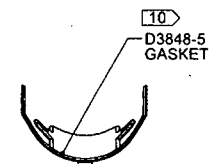
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#52402

# **D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR**



**SECTION C-C** C2-4  
SCALE 2X

**RELEASED**  
09/15/14

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D3849</b>	REV. B
MFG. APPR.	RF	TITLE <b>WEARPLATE ASSY</b>	SHEET 4 OF 10
APPROVED	RF	SCALE	NTS
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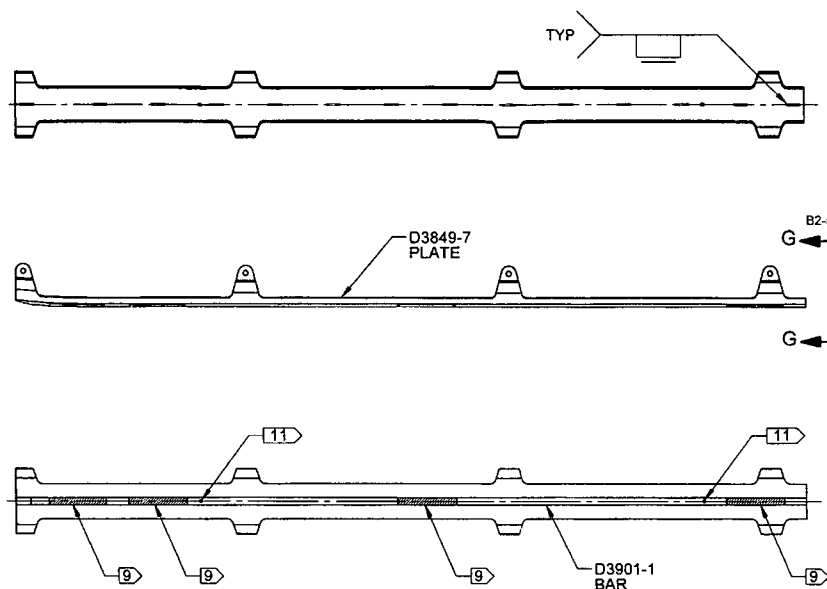
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

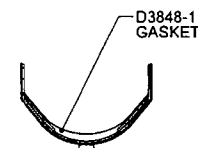


**D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR** 

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\varnothing 0.188$  HOLES FROM D3849-7 PLATE TO D3901-1 BAR

#50400



**SECTION G-G** C3-5  
SCALE 2X

**RELEASED**  
09/06/00

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 5 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

0.3 REF

R38.5

49.51

**D3849-1 PLATE**  
(MAKE FROM D3849-1F)

A6-10

#52402

0.050  
REF

7.72  
B

B

5.89

B  
51.313

36.000

DETAIL G

R0.38  
TYP

DETAIL F

A3-10

18.000

C3-10

DETAIL H

2.433  
TYP

6.642  
4 PL

Ø0.188 THRU  
2 PL

105°  
TYPR0.50  
TYP4.00  
TYPR0.06  
2 PL

34.500

7.00

B  
54.26 REF

**D3849-1F FLAT PATTERN** B

RELEASED  
01/27/54

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

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MFG. APPR.	<i>[Signature]</i>	D3849	SHEET 6 OF 10
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

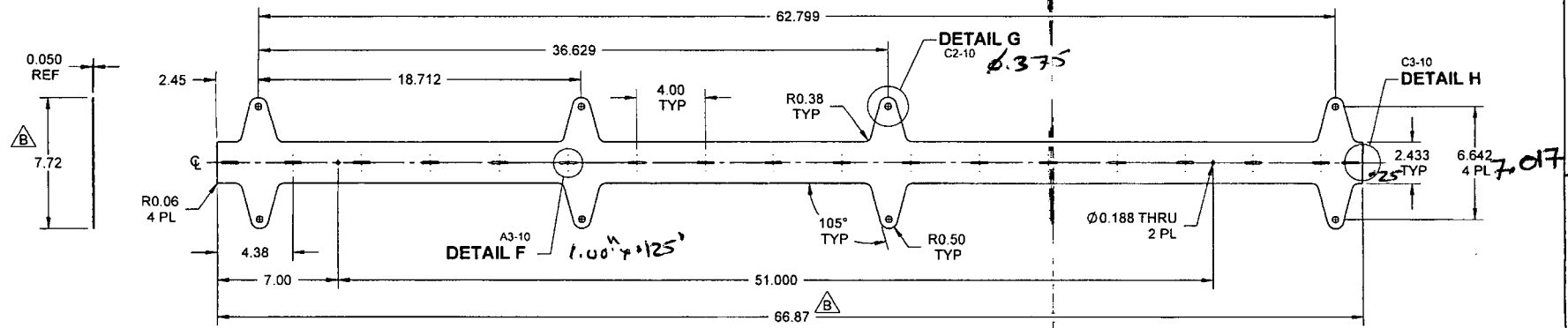
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D3849-3 PLATE**  
(MAKE FROM D3849-3F)

#52402



**D3849-3F FLAT PATTERN**

RELEASED  
09/07/51

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 7 OF 10
APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

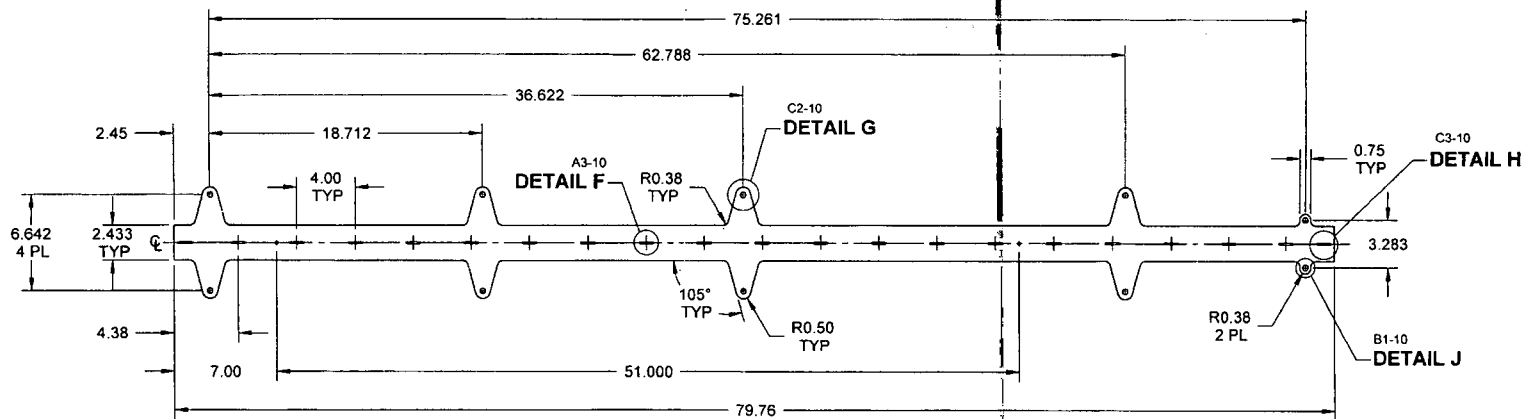
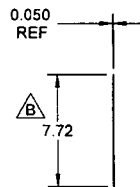
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D3849-5 PLATE**  
(MAKE FROM D3849-5F)

#52402



**D3849-5F FLAT PATTERN** B

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.30 lbs

RELEASED  
9/6/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 8 OF 10
APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

0.3 REF

R38.5

49.51

K

C5-10

**D3849-7 PLATE**   
(MAKE FROM D3849-7F)

#52402

0.050  
REF

7.88

51.313

C2-10  
**DETAIL G**

5.89

36.000

R0.38  
TYPA3-10  
**DETAIL F**

18.000

C3-10  
**DETAIL H**

2.45

2.433  
TYP6.801  
4 PLØ0.188 THRU  
2 PL105°  
TYPR0.50  
TYP4.00  
TYP

4.38

R0.06  
2 PL

34.500

7.00

54.26

**D3849-7F FLAT PATTERN** 

**RELEASED**  
09/07/15

## NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
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MFG. APPR.		SHEET 9 OF 10	
APPROVED		TITLE	SCALE
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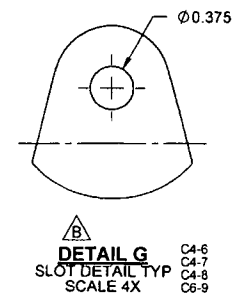
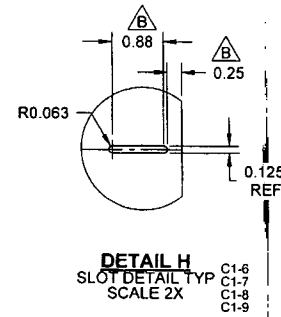
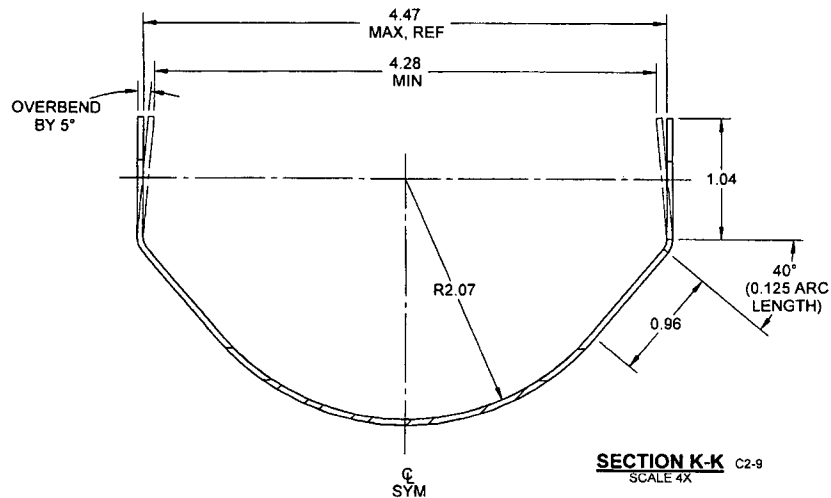
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

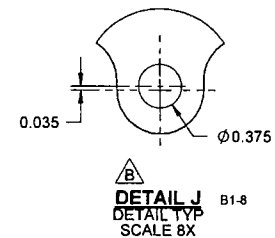
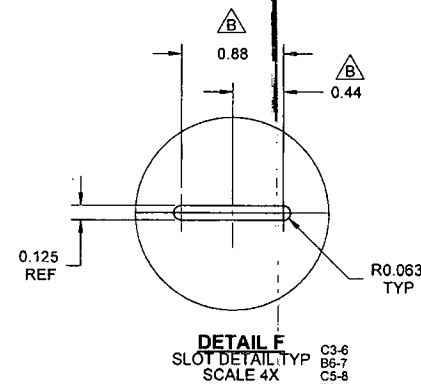
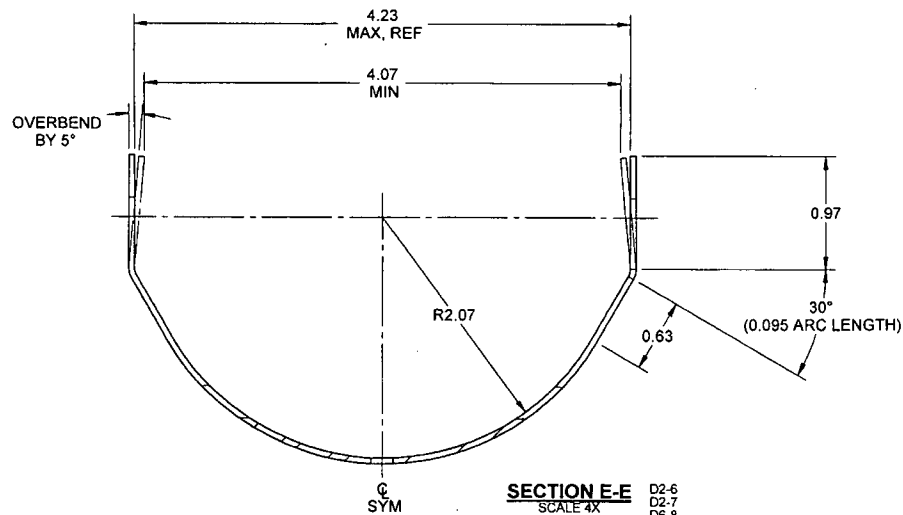
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#52402



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10/6/15/10

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries